

# Work Order ID 126924

Monday, December 01, 2014 11:33:33 AM

**\*126924\***

Page 1

Item ID: D3822-3KGY

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 11/27/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-12-01

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3822-3

Rev C

100

0.00

DAS

07

9-89

**\*100\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

17/12/16

105

0.00

DAS

07

9-89

**\*105\***

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

17/12/16

Temp: 150 deg. F

Time IN: 5:00 PM

Time OUT: 6:00 AM

DEC 15 2014

Per.....

**Work Order ID 126924**

Monday, December 01, 2014 11:33:33 AM

**\*126924\***

Page 2

Item ID: D3822-3KGY

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 11/27/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89

**\*110\***

Thermoform

~~Thermoforming Machine~~

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA027 using tool DT9072

Dwg Rev: CFolio Rev: B

Visually inspect for proper formation of each part

140

0.00

**\*140\***

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

DAS

07

9-89

14/12/16

**Work Order ID 126924****\*126924\***

Page 3

Monday, December 01, 2014 11:33:33 AM

Item ID: D3822-3KGY

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 11/27/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
<b>*150*</b>						x 1			
QC	Memo	0.00							
Quality Control	Complete FAI document								14/12/18

160 QC5- Inspect part completeness to step on W/O 0.00

**\*160\***

QC Memo 0.00

Quality Control

①

38  
9-89

DEC 18 2014

170 Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00

**\*170\***

Packaging Memo 0.00

Packaging

PDP b6917

DAS  
06  
9-89

DEC 18 2014

**Work Order ID 126924**

Monday, December 01, 2014 11:33:33 AM

**\*126924\***

Page 4

Item ID: D3822-3KGY

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 11/27/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

14/12/18

MF

14-12-18

# Picklist Print

Monday, December 01, 2014 11:33:32 AM

Page 1

Work Order ID: 126924

**\*126924\***

Parent Item: D3822-3KGY

**\*D3822-3KGY\***

Parent Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	3,800.000	5.25	6			DAS 07 9-89

**\*MKYD6185S 080-P3-52068\***

**\*\***

Kydex steel grey (52"x96"-.080)

12/12/18

Location	Loc Qty	Loc Code
LAIRD	1180	
m129546	347	
m129760	347	
m130383	486	
therm	2620	
119476	61	
121902	819	
122181	1046	
m127759	347	
m128321	347	

6 sq ft

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 126924
<b>Description:</b> Vertical Tunnel, Aft Center		<b>Part Number:</b> D3822-3KIV/KGY
<b>Inspection Dwg:</b> D3822	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> <u>DAS</u> 07 9-89	<b>Date:</b> 17/12/16
--	-----------------------

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.071"	✓			
0.020	Min	0.067"	✓			
0.035	Min	0.044"	✓			
0.4	Min	0.48"	✓			

<b>Measured by:</b> <u>DAS</u> 07 9-89	<b>Date:</b> 17/12/16
<b>Audited by:</b> <u>DAS</u> 38 N/A	<b>Date:</b> DEC 18 2016
<b>Prototype Approval:</b> <u>N/A</u>	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

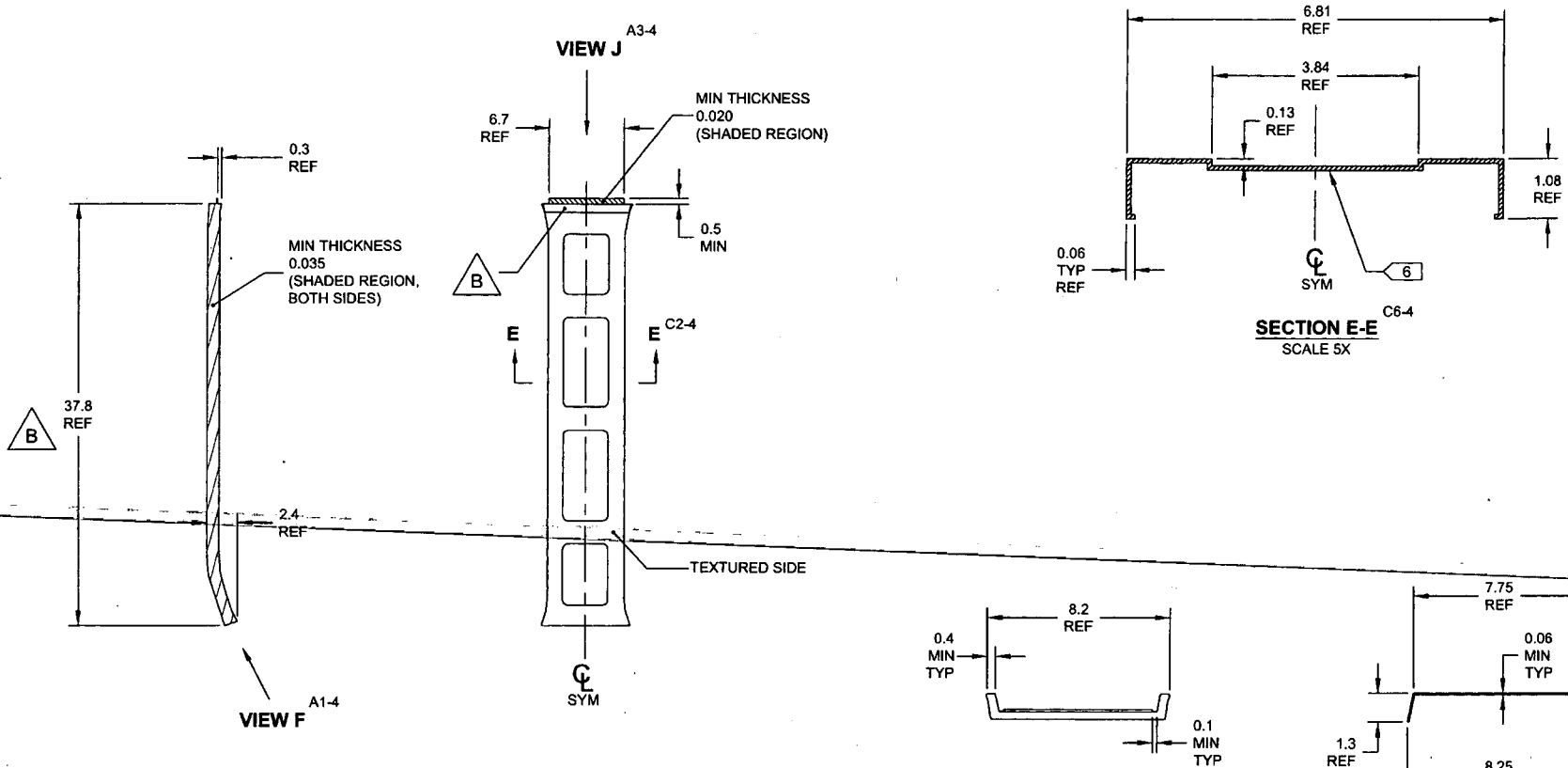
8 7 6 5 4 3 2 1

D

C

B

A



**D3822-3 VERTICAL TUNNEL, AFT CENTER**  
(BELL 206 A/B)

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA
DRAWN	PA
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	09.05.05

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. C
D3822	SHEET 4 OF 6
TITLE	SCALE
VERTICAL TUNNEL (BELL 206 A/B)	NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1